

Work Order ID 114818-2

March-13-14 11:47:27 AM

114818

Page 1

Item ID: D3719-041

Revision ID:

Item Name: Wearplate

Start Date: 3/13/14

Start Qty: 500

Required Date: 3/20/14

Req'd Qty: 500

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3719

Rev A

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3719 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

0.00

0.00

14 EL 14-3-14

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

14 EL 14-3-14

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

14

DAS
27
9-88

14/3/17

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Page 2

Item ID: D3719-041

Revision ID:

Item Name: Wearplate

Start Date: 3/13/14 Start Qty: 5.00

Required Date: 3/20/14 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Large Fab

Large Fab

Large Fab

Memo

1-Weld D3009-3 cups as per dwg D37192-Weld hard facing as per Dwg

D3719 A/R 2059B Hard Coat rod

Batch: m/26843-2059b

m/25054

0.00

0.00

(5)

212/MAL 14.03.19

140

140

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

(5)

14.03.19

DAS
9
9-89

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

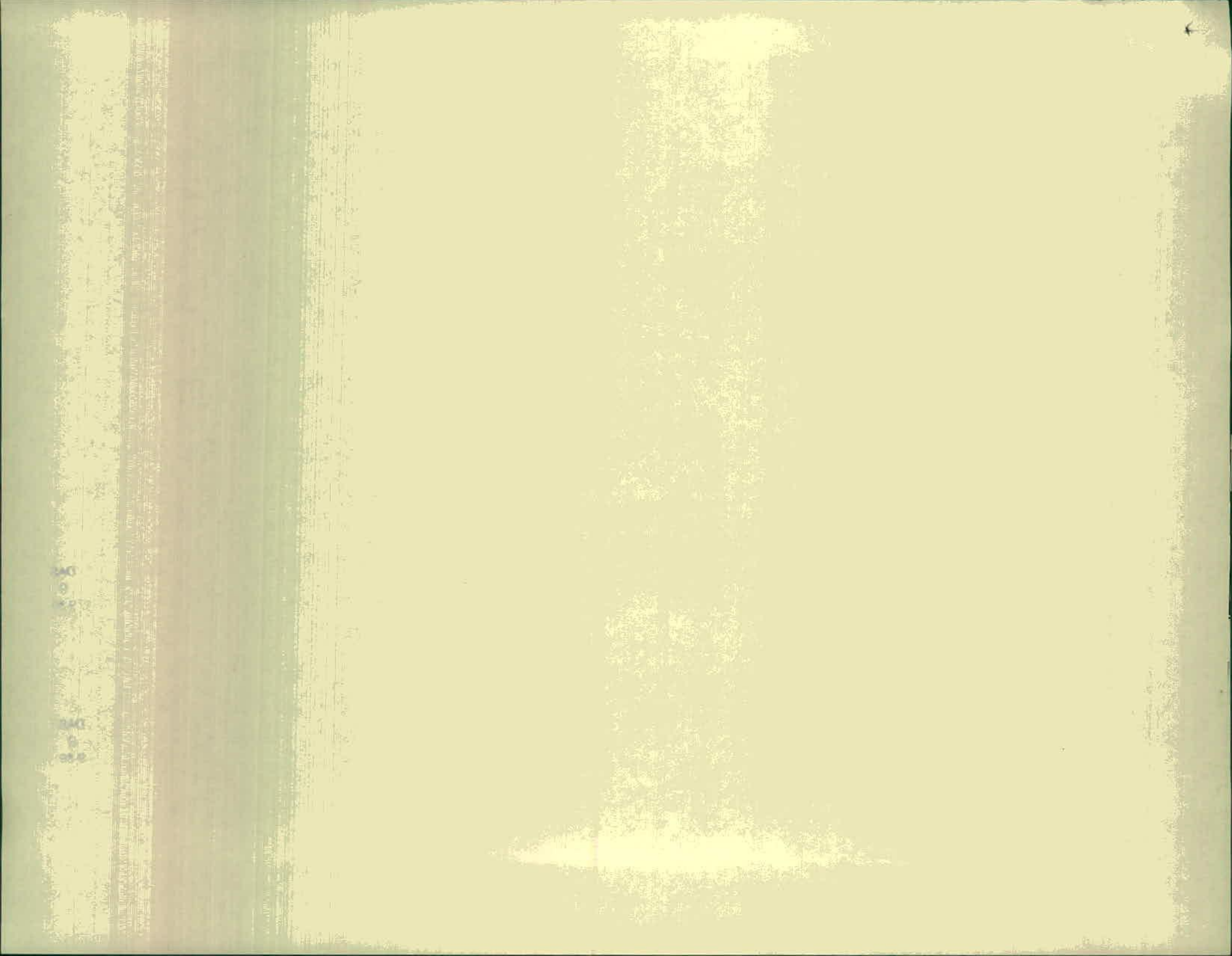
0.00

0.00

(5)

14.03.19

DAS
9
9-89



Work Order ID 114818

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Page 3

Item ID: D3719-041

Revision ID:

Item Name: Wearplate

Start Date: 3/13/14 Start Qty: 5.00

Required Date: 3/20/14 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME: 9:20

3:20 FINISH TIME:

OVEN TEMPERATURE: 9:50

0.00

5 14-3-19

DAS 34 9:59

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

DAS 27 9:59 14/3/19

5

180

Identify as per dwg & Stock Location: 51256

0.00

180

Packaging

Packaging

Memo

0.00

5x DAS 28 9:59 14-03-19

188

240
25
26

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March-13-14 11:47:27 AM

114818

Page 4

Item ID: D3719-041

Revision ID:

Item Name: Wearplate

Start Date: 3/13/14 Start Qty: 5.00

Required Date: 3/20/14 Req'd Qty: 5.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
Description

190

QC21- Final Inspection - Work Order Release

190

QC

Quality Control

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp*14-03-20**? 14-03-20*

Picklist Print

Page 1

March-13-14 11:47:26 AM

Work Order ID: 114818

114818

Parent Item: D3719-041

D3719-041

Parent Item Name: Wearplate

Start Date: 3/13/14

Required Date: 3/20/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-12-19 EC verified by DD
IPP Rev:B 08-09-25 add QC5 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3009-3		Manufactured	No			100	Each	152.0000	4	20			
D3009-3													

Cup

Location	Loc Qty	Loc Code
WA001	152	
103891	32	
108451 $\times 44$	60	
109092 $\times 12$	60	
130	sf	
	309.9370	0.565

M304S16GA

Purchased

No

M304S16GA

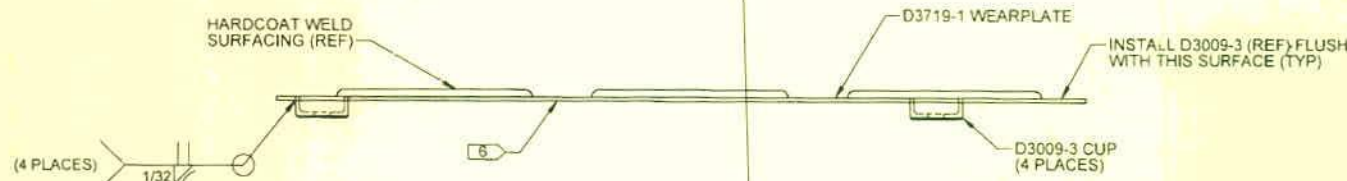
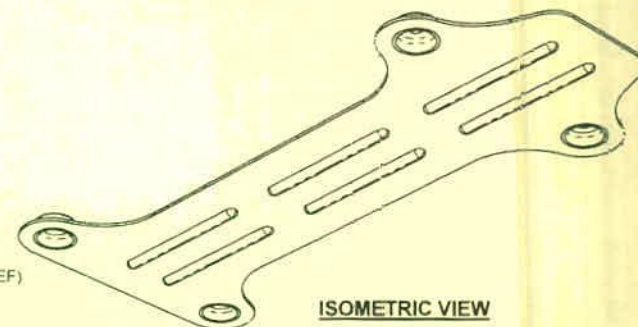
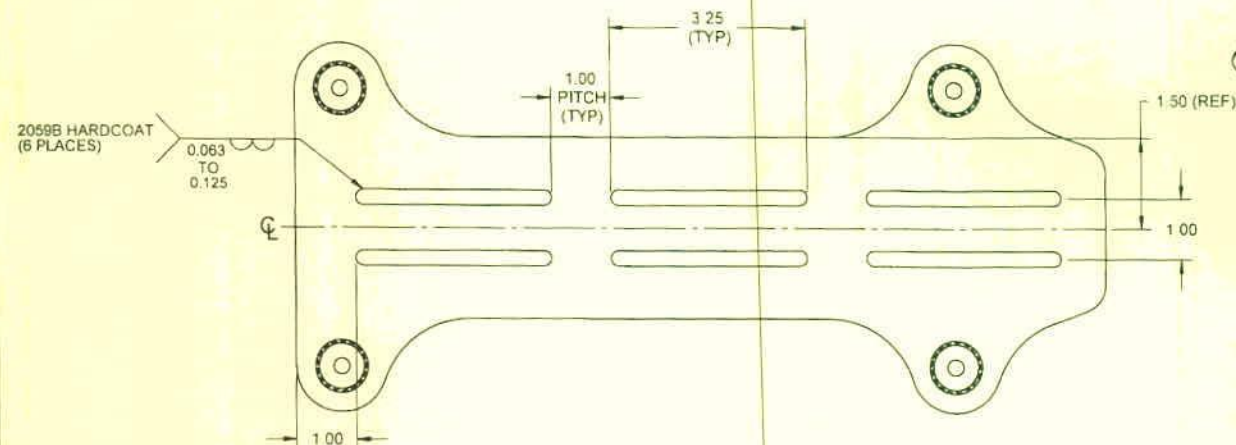
304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	309.937	
M126915	1.487	
M127821	126.13	
M128054	54.32	
M128423	128	

X56 14-03-18 MAL
EL 14-3-14

4.33

PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



D3719-041 WEARPLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4, 3, 5, 6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) WELD PER DART QSI 004

WLO 114818

RELEASED
07-01-07 100

REV.	NEW ISSUE	DESCRIPTION	DATE
A			07.12.12
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3719**

TITLE **WEARPLATE**

REV. A
SHEET 1 OF 2
SCALE 1:2

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